Quality Control

Work Order ID 65783

Wednesday, January 26, 2011 8:16:08 AM

Memo



Page 1

Item ID: D3442-1 Accept Setup Start **Revision ID:** Stop Shim Item Name: **Start Oty: 12.00 Start Date:** 1/25/2011 **Cust Item ID:** Required Date: 1/31/2011 Req'd Oty: 12.00 Customer: Reference: Run Start Date//-0/-24 Tooling: Approvals: Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool # Plan Tool ID Reject Accept Reject Insp. **Work Center ID** Description Run Hours Qty Code Number Stamp **Oty** Draw Nbr Revision Nbr D3442 Rev A 100 0.00 FLOW WATER JET B 11-2-1 Wateriet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3442 204 .63D Dwg Rev: Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1B11-2-1 OC 0.00 Memo Quality Control 120 QC8- Inspect parts - second check

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Part No):		PAR #:	Fault Cate	egory:	NC	R: Yes	No DQ	A:	Date: _	
	Res	olution:	1	Disposition	on:	QA	A: N/C CIO	osed:		Date: _	
NCR:			l L	WORK ORE	ER NON-CONFO	ORMANC	E (NCR)			
D.47F	0.750	Desci	ription of NC		Corrective Action	Section B		Verifi	cation	Approval	Approval
DATE	STEP		Section A	Initial Chief Eng	Action Descri Chief Eng	ption ————	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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Page 2

Wednesday, January 26, 2011 8:16:08 AM Item ID: D3442-1 Accept Setup Start Revision ID: Item Name: Shim Stop Start Date: 1/25/2011 **Start Oty: 12.00 Cust Item ID:** Required Date: 1/31/2011 Req'd Otv: 12.00 **Customer:** Reference: Run Start Process Plan: Approvals: Date: ___ Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description Qty **Run Hours** Code Qty Number Stamp 130 0.00 Small Fab Small Fab 0.00 Memo Small Fab Deburr if necessary. QC5- Inspect part completeness to step on W/O 140 QC 0.00 Memo Quality Control Identify as per dwg & Stock Location: WA 150 0.00

Packaging

Packaging

Memo

*****STOCK IN BASKET CELL*****

0.00

11-02-01

Dart Aerospace Ltd

W/O:	· ·	· · · · · · · · · · · · · · · · · · ·		W	ORK ORDER CHANG	ES		······································		· ·
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Work Order ID 65783

Wednesday, January 26, 2011 8:16:08 AM



Page 3

Item ID:

D3442-1

Accept

Setup Start



Revision ID:

Start Date:

Item Name: Shim

Required Date: 1/31/2011

1/25/2011

Start Qty: 12.00

Req'd Qty: 12.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Stop



Date:

SPC (Y/N):

Date:_

Sequence ID/ **Work Center ID**

160

Operation **Description**

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty Number.

Insp. Stamp

Memo

0.00

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Quality Control

Dart Aerospace Ltd

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NCR:			1	WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Descr	ription of NC		Corrective Action Secti			cation	Approval	Approval
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Picklist Print

Wednesday, January 26, 2011 8:16:17 AM

Work Order ID: 65783

Parent Item: D3442-1

Parent Item Name: Shim



Start Date: 1/25/2011

109057

Required Date: 1/31/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP A□05.09.02□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA	ISKII BUSII KAI IBAI	Purchased	No			100	sf	66.5296	0.04	0.505263	1,		
											B11-	J-(

304/316 .032 Sheet

 Location
 Loc Oty
 Loc Code

 MAT20
 66.5296

 109023
 30.2896

 109057
 36.24



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D3065-5DART AEROSPACE LTD	Work Order: US783
Description: Shim	Part Number: D3442-1
Inspection Dwg: D3442 Rev: A	Page 1 of 1

	FIR	ST ARTICLE I	NSPECT	ION CHI	ECKLIST		
		X First Art	icle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
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0.034	+/-0.010	, 634	0		V		
0.750	+/-0.010	,747	2		V		
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Date:	11-9-1	Date:	11/00/01			Date:	N/A
Rev Date	Change				R	evised by	Approved

Meas	ured by:	iR	Audited by: \(\frac{\cappa}{\cappa} \)	Prototype Approval:	N/A
	Date:	11-9-1	Date: 1(102/0/	Date:	N/A
Rev	Date	Change		Revised by	Approved
	07.07.18	New Issue		KJ/JLM 🖟	L F

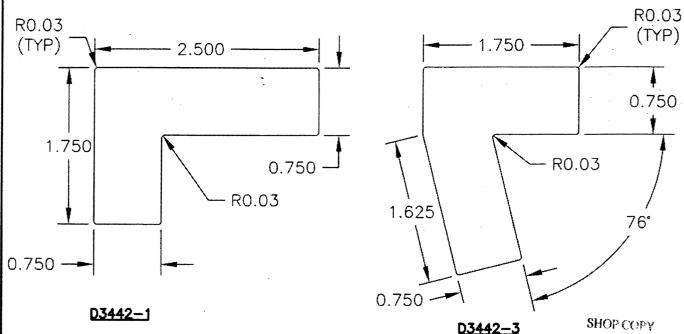
Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANGI	ES				·····
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DATE	M	<u> </u>	TITLE	SCALE
05.0	6.03		SHIM	1:1
Α		05.06.03	NEW ISSUE	



D3442-1/-3 SHIM

MATERIAL:

AISI 304/316 SS SHEET 21 GAUGE (0.034 THICK)

(REF DART SPEC M304S21GA)

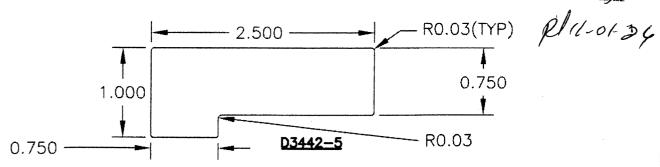
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NONE

3) ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RETURN TO **ENGINEER** NO UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER



D3442-5 SHIM

1) MATERIAL: AISI 304/316 SS SHEET 16 GAUGE (0.063 THICK)

(REF DART SPEC M304S16GA)

2) FINISH:

NONE

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED RELEASED

05.08.19

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